

Date: Wednesday, 1/16/2008 2:23:52 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : T-BEAM EXTRUSION
Job Number : 36793	
Estimate Number : 10043	
P.O. Number :	Part Number : D6201
This Issue : 1/16/2008 S.O. No. :	Drawing Number : D6201 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LANDING GEAR	Drawing Revision : A
Previous Run : 35952	Material :
Written By :	Due Date : 1/23/2008 Qty: 40 FT Um: Each
Checked & Approved By : <u>08.01.16</u>	
Comment : Est. A: 01.05.15 New Issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 5476

C208/01/17

40 FT

a) Description: T-beam extrusion

b) 4.00" x 4.00" x 0.375"

c) Minimum Ultimate Tensile Strength = 38ksi

d) Minimum Yield Tensile strength = 35ksi

e) Material: 6061-T6/T6511 (QQ-A-200/8)

f) Material certification required

2.0	D6201P	T Extrusion 4X4X3/8
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Comment: Qty.: 1.0000 f(s)/Unit Total : 20.0000 f(s) ✓

T Extrusion 4X4X3/8

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

C208/01/23

40 FT

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6104

C 08/01/25 + 40 FT

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 28/01/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: T-BEAM EXTRUSION

Job Number: 36793

Part Number: D6201

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

02/08/01/25

(40FT)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(40)

Comment: FINAL INSPECTION/W/O RELEASE

2/28/01/30

Job Completion



2/28/01/28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

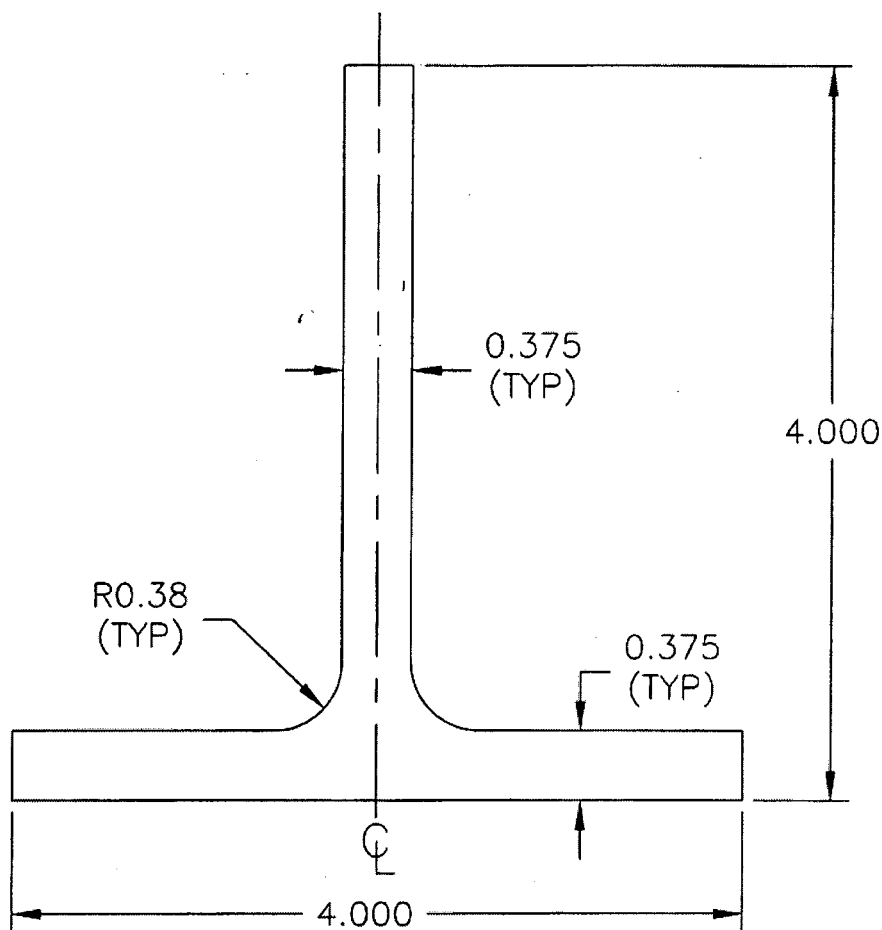
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D6201	REV. A SHEET 1 OF 1
DATE 01.04.10		TITLE T-BEAM EXTRUSION	SCALE 1:1
A	01.04.10	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.04.23 *[Signature]*



D6201-XXX T-BEAM EXTRUSION
WHERE XXX IS LENGTH IN INCHES

EG.
D6201-027 IS 27 INCHES LONG

PURCHASE MATERIAL: ALUMINUM "T"-EXTRUSION ROUND FILLET
4.000" x 4.000" x 0.375"
6061-T6/T6511 (QQ-A-200/8)
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM YIELD TENSILE STRENGTH = 35 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36793

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**Purchase Order**

Date Jan 17, 2008	Page 1
Purchase Order Number PO00005476	

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

FAKED**Vendor Address:**

Magna Stainless
525 avenue Meloche
Dorval, QC H9P 2W2
Canada
Phone (800) 363-6646
Fax (514) 631-0013

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-MAG002	Jan 17, 2008	N30	yours	Jan 18, 2008

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
40.0000	D6201P ✓ 208/01/22	T Extrusion 4X4X3/8 Comments: MATERIAL: 6061-T6/T6511 9QQ-A-200/8) T-BEAM EXTRUSION 4.00" X 4.00" X 0.375" MINIMUM ULTIMATE TENSILE STRENGTH = 38KSI MINIMUM YIELD TENSILE STRENGTH = 35KSI <div>MATERIAL CERTIFICATION REQ'D UPON DELIVERY</div>	1/18/2008	No	8.450000	f	338.00

Comments:	Tax Summary:		Less:	
	GST	16.90	included tax	0.00
	ONT PST	0.00	Subtotal	338.00
	Entered By: CL CLAVOIE		Total tax	16.90
Approved By:			Total purchase order in	
			CAD Dollars	354.90

THEORY, RECONSTRUCTION, AND THE STATE IN ARGENTINA / MARGARET M. MCGLOTHLIN IN GOOD CONDITIONS BY:

PANASIA ALUMINIUM (CHINA) LIMITED

Aluminium Mill Certificate

Cert. No.: PAAV-MC0703036

CUSTOMER: Magna Stainless Inc

PO No.: 065464-JC

Alloy & Temper: 6061-T6511

Container No.: ZCSU9010606

Contract No.: NIL

Standards: ASTM-B308

Date of shipment: 2007.03.12

QQA-200/16

Chemical Composition (%)

Heat No.	Si	Mg	Fe	Cu	Mn	Zn	Cr	Ti	Al
Standard	0.40-0.80	0.80-1.20	0.7max.	0.15-0.40	0.15max.	0.25max.	0.04-0.35	0.15max.	Rem.
20070306401	0.489	0.890	0.242	0.194	0.026	0.038	0.047	0.018	Rem.

Tensile Test Result

Heat No.	Die No.	Customer part No.	Description	Tensile Strength		Yield Strength		Elongation % 10 min.
				N/mm ²	Ksi	N/mm ²	Ksi	
				260min.	38min.	240 min	35min.	
20070306401	C10000071		Channel 6x2.5x0.25	280	41	255	37	11.0
20070306401	E10000004		Tee 4x4x0.375	285	42	255	37	10.8
20070306401	C10051		Channel 4x2x0.187	290	42	265	39	10.9

Hardness Test Result

Section No.	HRE	Webster	Other Remarks
C10000071	91	15.6	
E10000004	94	16.2	
C10051	92	15.9	

The above result was done on testing samples and the mill shall guarantee the same quality for the same batch of products. It is certified that this material conforms in all respects to the requirements of the above standards latest revision.

QC: Chenghao Zhong

Checked By: Junxian Luo



BW-550